

Date: Thursday, 16/04/2009 9:43:00 AM  
 User: Julie Dawson

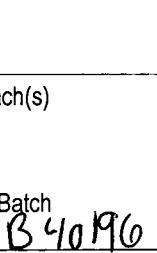
## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 47244			Part Number	: D2596	
Estimate Number	: 10346			Drawing Number	: D2596 REV D	
P.O. Number	:			Project Number	: N/A	
This Issue	: 16/04/2009		S.O. No. :	Drawing Revision	: D	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	SKIDTUBES	Due Date	20/04/2009
Previous Run	: 46904				Qty:	6
Written By	:			Um:	Each	
Checked & Approved By	: <u>JUL 09.04.16</u>					
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n -'I' Beam Web 4"	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Extrusion "I" Beam Web 4"			
	Pick;	Qty Part Number Description Batch	
	1	D2500-3-100	Extrusion B40196
<b>Comment:</b> LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr			
2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 47244

Part Number: D2596

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

PMC 09-04-16 (2)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/17 JF

Job Completion



MF 09-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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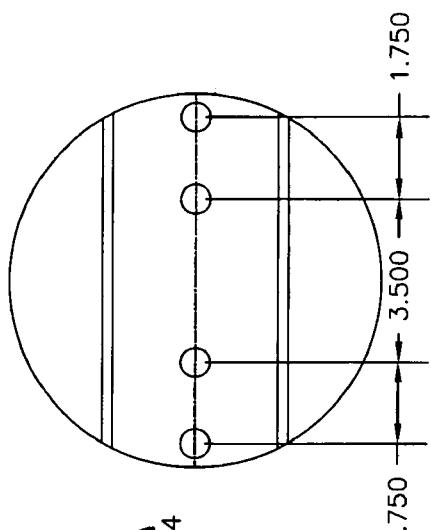
NOTE: Date & initial all entries

**DART**

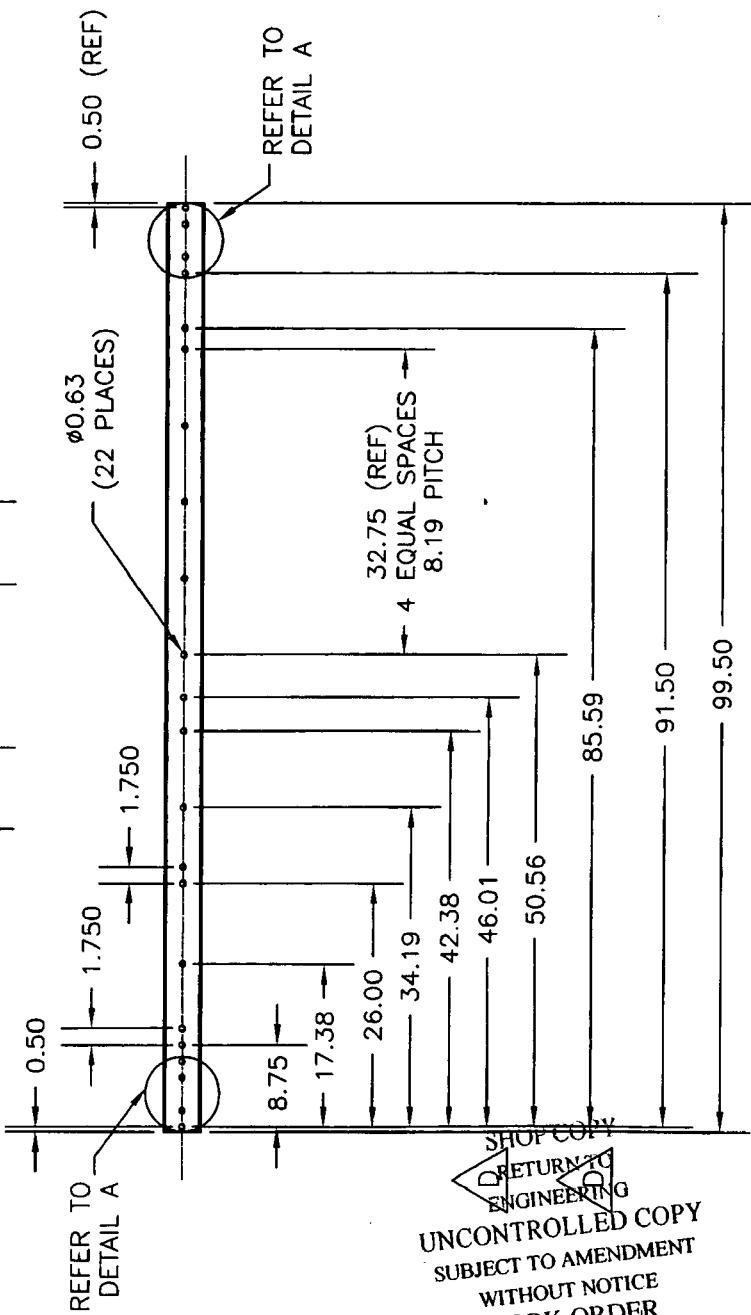
DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1	
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20	
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

RELEASED  
07-06-28 #

07.06.18



**DETAIL A** 1:4  
SCALE



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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